

Work Order ID 53548

November 9, 2009 10:01:25 AM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 09/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 09-11-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3825

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825-2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825-3- c'sink hole as per dwg-4- remove identification markings-5- deburr

PL 09 11 12

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

6 09-11-13

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825- A/R ER316 S.S. Rod Batch *1109213* -2- grind bushing weld flush where indicated on dwg D3825 -3- deburr if necessary

PL 09 11 16

Work Order ID 53548

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Page 2

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Start Date: 09/11/2009 Start Qty: 6.00



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Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							PD 09.11.16
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							Scrub 07
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00							SAD 09-11-17

(46)

(6)

Work Order ID 53548

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Page 3

Item ID: D3825-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 09/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/17
MF
09-11-17

Picklist Print

November 9, 2009 10:01:29 AM

Page 1

Work Order ID: 53548



Parent Item: D3825-041RevA



Parent Item Name: Rib Assembly (Basket End)

Start Date: 09/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2327-3RevD Manufactured No



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

34

44274

15

44365

9

51126

10

D3759-1RevA Manufactured No



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

30

51473

30

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

600

113082

600

Main Warehouse

WA

7.5272947

112398

7.5272947

Cpl 09.11.16

(6) ✓

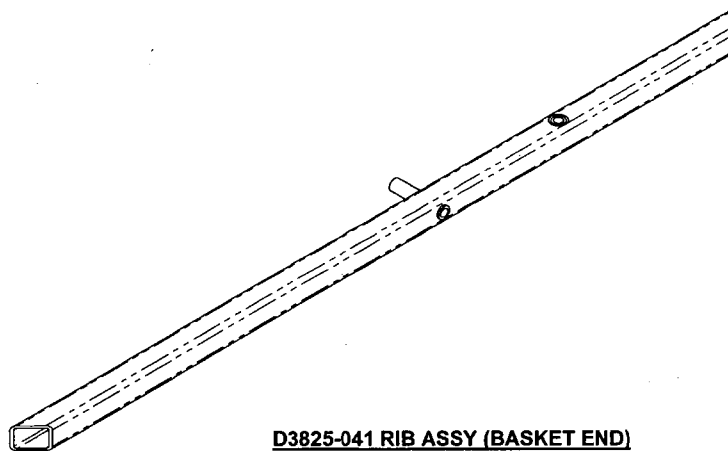
Cpl 09.11.16

(6) ✓

SAD 09.11.12

13.4211

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53548
3109-11-9

RELEASED
09/11/18

NOTES:

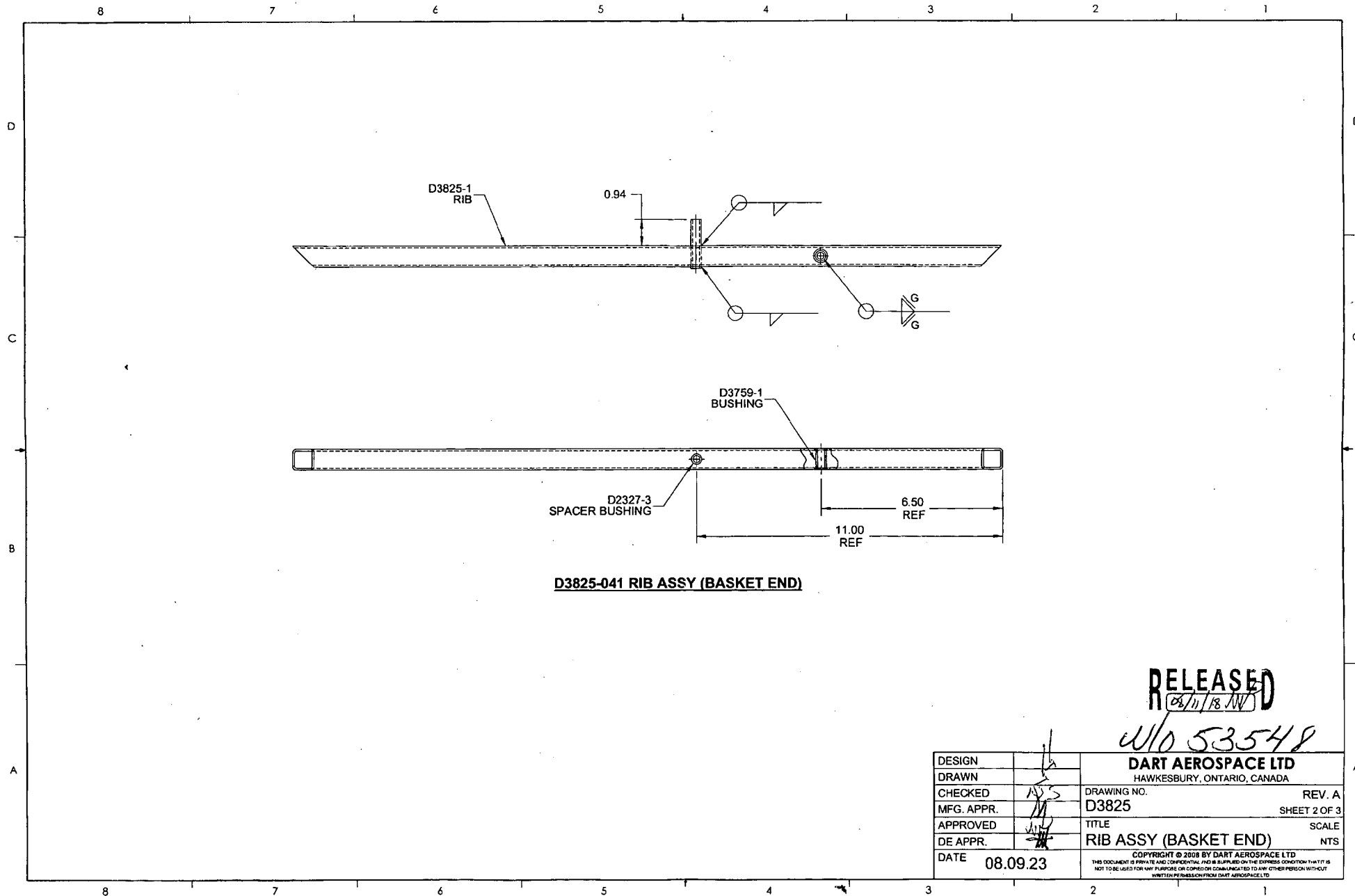
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

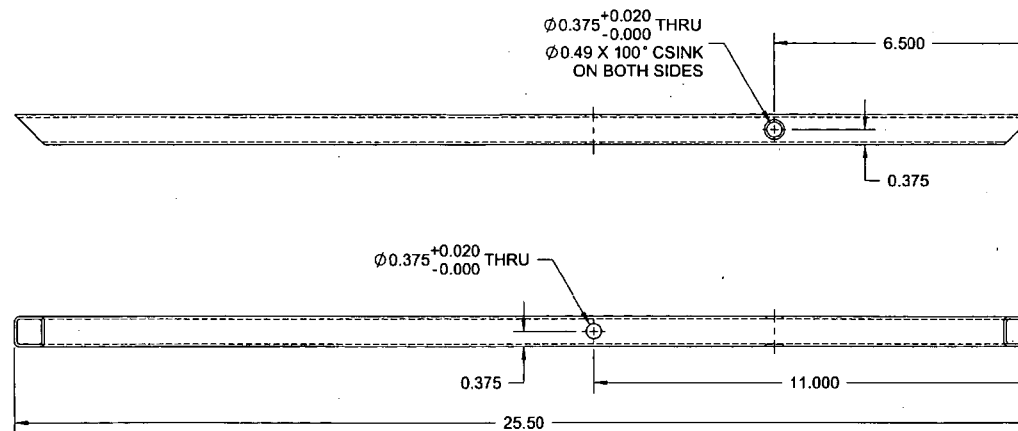
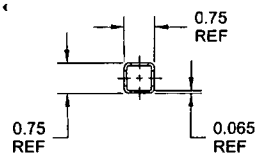
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RELEASED
08/11/18 NW

W/D 53548

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	MS	DRAWING NO. D3825	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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D3825-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.18 lbs

DESIGN		RELEASED W10 53548 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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